

SPLIT-2

Work Order ID 43603 - 2

July 1, 2009 10:43:24 AM



Page 1

Item ID: D3022-1 GY

Accept



Setup Start



Revision ID: B

Stop



Item Name: Seat Pan

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr Revision Nbr

D3022

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

1-Cut as per Dwg D3022 Dwg Rev: _____ Prog Rev: _____*** grind direction along 31.700" *** 2-Deburr if necessary

✓

110

QC2- Inspect parts off machine FAI/FAIB

0.00



Memo

0.00

QC

Quality Control

✓

120

QC8- Inspect parts - second check

0.00



Memo

0.00

QC

Quality Control

✓

Work Order ID 43603

July 1, 2009 10:43:24 AM



Page 2

Item ID: D3022-1

Accept



Setup

Start



Revision ID: B

Stop



Item Name: Seat Pan

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3022

EL
9-7-1

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

- SORRY FOR

150



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Transfer drill Seat Pan From Frame
using D3017-041 ***** 2-Deburr

*****Transfer drill in D3022-1

- EL 9-7-1

Work Order ID 43603



Page 3

July 1, 2009 10:43:24 AM

Item ID: D3022-1

Accept



Setup

Start



Revision ID: B

Stop



Item Name: Seat Pan

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC

Quality Control

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC5- Inspect part completeness to step on W/O

0.00

-Sor/07/01

0.00

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

H 09-07-01 X1

0.00

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

7:30AM

FINISH TIME:

3:20PM

OVEN TEMPERATURE:

1109041 09-07-06 X1

Work Order ID 43603

July 1, 2009 10:43:24 AM



Page 4

Item ID: D3022-1

Revision ID: B

Item Name: Seat Pan

Start Date: 7/15/09 Start Qty: 1.00

Accept



Setup Start



Stop



Required Date: 8/03/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

BK

09-07-6

Ø

QC

Quality Control

Memo

0.00

200

Identify as per dwg & Stock Location

Store

0.00

9/1/6

QA SP

Packaging

Packaging

Memo

0.00

210

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

09/07/09 JF

U 9/07/09

Picklist Print

July 1, 2009 10:43:24 AM

Page 1

Work Order ID: 43603



Parent Item: D3022-1RevB



Parent Item Name: Seat Pan

Start Date: 7/15/09

Required Date: 8/03/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	111.0120	1.7086			

2024-T3 .032 sheet



Warehouse

Location

Main Warehouse

MAT	Loc Qty	Loc Code
102942	1.5	
105555	5	
106272	8.47	
108595	3	
109240	7.02	
110778	34.02	
111699	49	
18147	3	

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SEAT PAN
Job Number	43603	- 2	Part Number	D30221 B
Estimate Number	11092		Drawing Number	D3022 REV A
P.O. Number	:		Project Number	N/A
This Issue	20/11/2008	S.O. No. :	Drawing Revision	A B
Prsht Rev.	NC		Material	:
First Issue	11	Type : LARGE FAB ASSY	Due Date	20/12/2008
Previous Run	43392		Qty:	1
Written By	:		Um:	Each
Checked & Approved By	: 240 08.11.21			
Comment	Est. C	02.01.23 Revised NG		
	Est Rev:D	08-04-16 now water jet DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S032	2024-T3 .032 sheet	
		Comment: Qty.: 1.7044 sf(s)/Unit Total : 1.7044 sf(s) 2024-T3 .032 sheet Material: 2024-T3 sheet (QQ-A-250/4) 0.032" Batch: 110718 RB 9-2-10	(2)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3022 Dwg Rev: <u>B</u> RB 9-2-10 Prog Rev: <u>B</u> → P10 *** grind direction along 31.700" ***	
		2-Deburr if necessary RB 9-2-10	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		RB 9-2-10	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		S 09/02/10 (72)	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		1-Form as per Dwg D3022	
		S 09/02/23 (2)	

ate: Thursday, 20/11/2008 3:34:26 PM
ser: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 43603

Part Number: D30221

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 6/2011 (D)

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Transfer drill Seat Pan From Frame

*****Transfer drill in D3022-1 using D3017-041 *****

2-Deburr

EL 9-7-1 (D)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 6/2011 (D)

9.0 ✓ HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0 ✓ POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

11.0 ✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 ✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Date: Thursday, 20/11/2008 3:34:26 PM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 43603

Part Number: D30221

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART

QA COPY
ISSUE DATE

DESIGN	DRAWN BY
UP	UP
CHECKED	APPROVED
DATE	
01.05.18	
DRAWING NO.	
D3022	
TITLE	
SEAT PAN	
SCALE	
1:5	

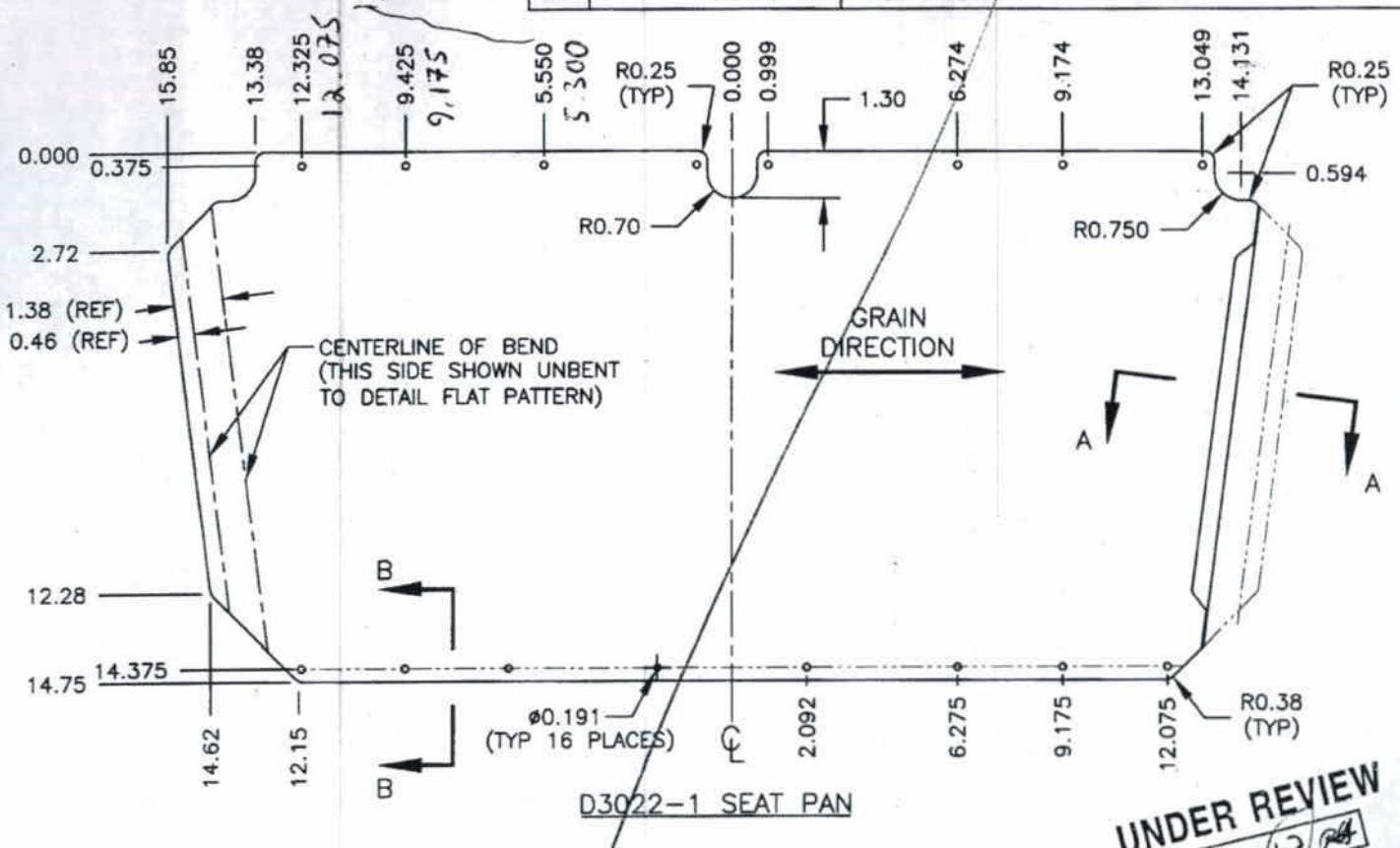
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. A

SHEET 1 OF 1

1:5

A 01.05.18 NEW ISSUE



UNDER REVIEW
03.04.17/R4

DIMS 13.525, 14.255, 5.551, 14.131
WOULD BE 14.131
SUBTRACTED BY 0.25

03.11.25

0.37
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO 1305

NOTES:

1) SHAPE IS SYMMETRIC ABOUT CENTERLINE, HOLE PATTERN IS NOT

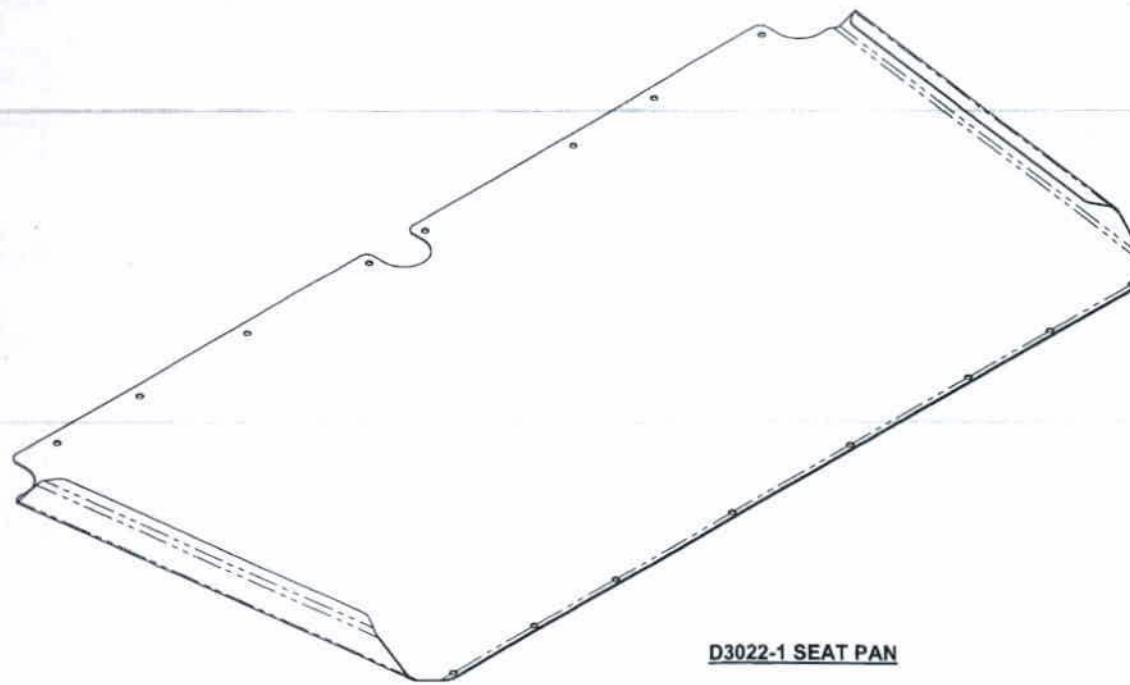
2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK

3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

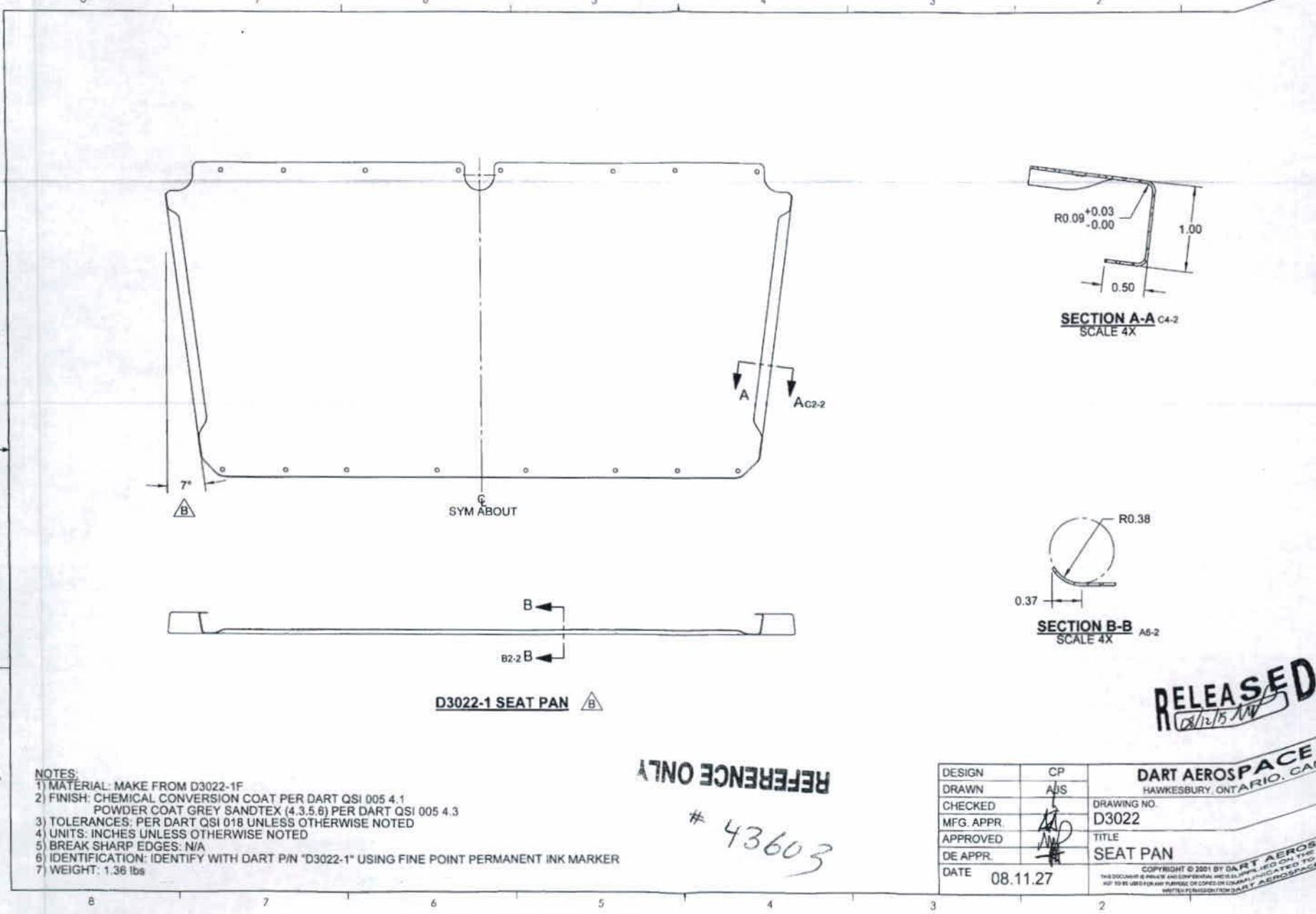


D3022-1 SEAT PAN

REFERENCE ONLY

43603

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. B7-2.7" DIM ADDED. D7-3 12.075 WAS 12.325. D6-3 9.175 WAS 9.425 & D5-3 5.300 WAS 5.550. REASON: DRAFTING ERROR		
A	NEW ISSUE		
REV.	DESCRIPTION		
	DESIGN	CP	AJS
	DRAWN	AJS	08.11.27
	CHECKED		CP
	MFG. APPR.	AJS	01.05.15
	APPROVED		BY
	DE APPR.		DATE
	DATE	DART AEROSPACE LTD	
	08.11.27	HAWKESBURY, ONTARIO, CANADA	
		REV. B	
		SHEET 1 OF 3	
		SCALE	
		NTS	
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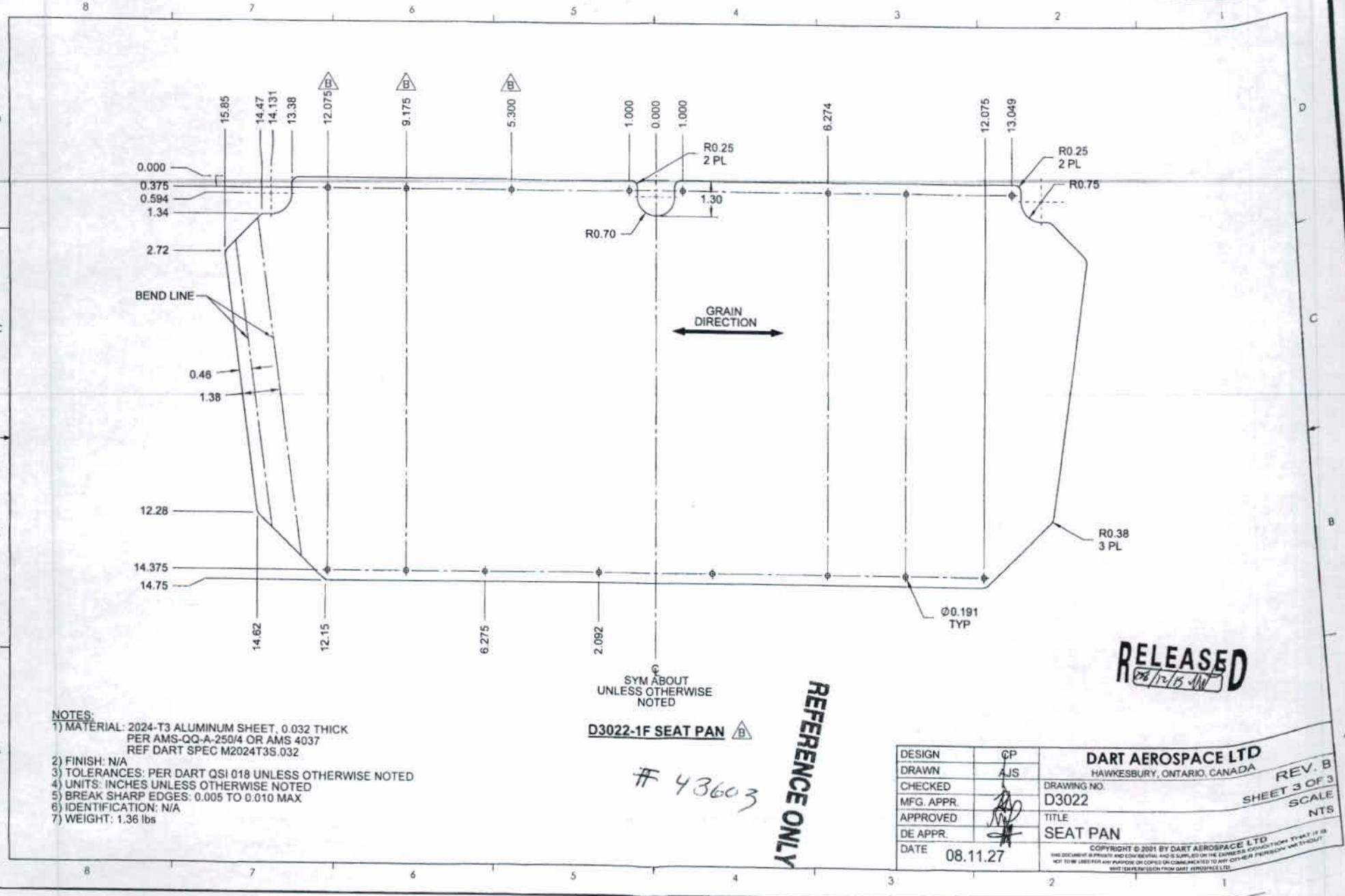


DESIGN	CP	DART AEROSPACE LTD
DRAWN	ADS	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. B
MFG. APPR.		SHEET 2 OF
APPROVED		SCAL
DE APPR.		NT
DATE	08.11.27	1

DRAWING NO.
D3022

TITLE
SEAT PAN

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NOTES.

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 1.36 lbs

SYM ABOUT
UNLESS OTHERWISE
NOTED

D3022-1F SEAT PAN B

F 43603

REFERENCE ONLY

DESIGN	CR
DRAWN	AJ
CHECKED	
MFG. APPR.	<u>11/11/11</u>
APPROVED	<u>11/11/11</u>
DE APPR.	<u>11/11/11</u>
DATE	08.11.27

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